

Date: Wednesday, 12/5/2007 12:56:51 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE  
 Job Number : 35741  
 Estimate Number : 10366  
 P.O. Number :  
 This Issue : 12/5/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : LANDING GEAR  
 Previous Run : 35740  
 Written By :  
 Checked & Approved By : AS 07.12.05  
 Comment : Est Rev A 05.10.13 New Issue KJ/JLM  
 Est Rev B 06-06-08 As per DSI9336 JLM  
 Est Rev C 07-12-03 ECN 1072 DD verified by:JLM

Part Number : D412742013  
 Drawing Number : N/A  
 Project Number : N/A  
 Drawing Revision : N/A  
 Material :  
 Due Date : 12/30/2007 Qty: 1 Um: Each

POSITIVE RECALL

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



AS 07.12.06

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG003 001/per ECN 1104 u 08-01-14

2.0 35741A FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY  
 D412-742-043 B 35741A

SC

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

4.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2571 Saddle Fwd Outside 35741A

B37282

AS 08/03/19 (X)

5.0 D2572 Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2572 Saddle Fwd Inside 1735932

B37283

AS 08/03/19 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: FLOAT SKIDTUBE

Job Number: 35741

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description  
1 D2573 Saddle Aft Outside

Batch

~~735933~~

B37566

AS

08/03/19

(X1)

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description  
1 D2574 Saddle Aft Outside

Batch

~~736325~~

37285

AS

08/03/19

(X1)

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2876 Saddle Spacer

Batch

~~37285~~

B36275

AS

08/03/19

(X1)

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2877 Saddle Spacer

Batch

B34818

AS

08/03/19

(X1)

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description  
16 D3403-1 Bushing

Batch

B36303

AS

08/03/19

(X1)

11.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description  
4 D2747 Bolt

Batch

B36331

AS

08/03/19

(X1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FLOAT SKIDTUBE

Job Number: 35741

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Set Screw B28093

AS 08/03/19 (X)

13.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

M106519

AS 08/03/19 (X)

14.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

M103914

AS 08/03/19 (X)

15.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

M104289

AS 08/03/19 (X)

16.0

D36723

PHENOLIC WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)  
PHENOLIC WASHER

B34471

All Same Batch with comp Not in

AS 08/03/19 (X)

17.0

AN960C416L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)  
WASHER

M105793

AS 08/03/19 (X)

18.0

D36729

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
PHENOLIC WASHER

B35523

AS 08/03/19 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35741

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960C616L

WASHER



Need to  
Remove 8 from  
comp.



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
WASHER

M18918

AS 08/03/19

(X)

20.0

D367211

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
PHENOLIC WASHER

B35524

AS 08/03/19

(X)

21.0

MS210434

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)  
Nut

M107101

AS 08/03/19

(X)

22.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: M106302

AS 08/03/19

(X)

23.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Pick:

Qty Part Number  
8 D3403-3

Description  
Bushing

Batch

B330

35635

B37146

AS 08/03/19

(X)

24.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Pick:

Qty Part Number  
1 D3405-041

Description  
GHW Lug

Batch

B35779

B35779

AS 08/03/19

(X)

25.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Pick:

Qty Part Number  
1 D3405-043

Description  
GHW Lug

Batch

B34841

AS 08/03/19

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35741

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

M19529 x2 M107287 x2

AS 08/03/19 (X)

27.0

MS210434

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M107101

AS 08/03/19 (X)

28.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

~~155578~~ 35780

AS 08/03/19 (X)

29.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

33519

AS 08/03/19 (X)

30.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

33276

AS 08/03/19 (X)

31.0

AN3C37A

BOLT



Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)

BOLT

M106169

AS 08/03/19 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 12/5/2007 12:56:51 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 35741

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description:

32.0

AN3C40A

BOLT

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
BOLT M106169

AS 08/03/19 (X)

33.0

AN3C41A

BOLT

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
BOLT M106176

AS 08/03/19 (X)

34.0

AN3C42A

BOLT

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
BOLT M106169

AS 08/03/19 (X)

35.0

AN3C43A

BOLT

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
BOLT M106227

AS 08/03/19 (X)

36.0

AN3C46A

BOLT

Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)  
BOLT M106169

AS 08/03/19 (X)

37.0

AN960C10L

washer

Comment: Qty.: 26.0000 Each(s)/Unit Total: 26.0000 Each(s)  
washer M107008

AS 08/03/19 (X)

38.0

MS210433

Nut

Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)  
Nut M107214

AS 08/03/19 (X)

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S odc/20 x

B35741A

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 08/03/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 12/5/2007 12:56:51 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 35741

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: E

*SD* *AS* *08/03/20* *(A)*

41.0

QC21

FINAL INSPECTION/W/O RELEASE



*(D)*

Comment: FINAL INSPECTION/W/O RELEASE

*208/03/04*

Job Completion



*U 08-03-24*

**POSITIVE RECALL**

EFFECTIVE *07-12-14*

AUTH *1*

RELEASED *U*

DATE *08-03-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

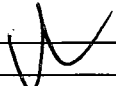
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 29/01/2008 7:55:59 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FLOAT SKID ASSEMBLY
<b>Job Number</b> :	35741A		
<b>Estimate Number</b> :	10756		
<b>P.O. Number</b> :		<b>Part Number</b> :	D412742043
<b>This Issue</b> :	29/01/2008	<b>Drawing Number</b> :	D3391 REV G
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	05/12/2007	<b>Drawing Revision</b> :	D
<b>Previous Run</b> :	35740A	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	30/12/2007
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	1 Um: Each
<b>Comment</b> :	Est Rev A 05.10.13 New Issue KJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev:C 07-05-28 As per Rev F JLM Est Rev:D 07-12-04 ECN 1072 DD verified by:JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

JLM

2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M105005

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M105585

Expiry date: 08-07

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251

A/R Sikaflex-241/-291 M105585

Expiry date: 08-07

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

08-03-17 (X)

08-03-17 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 29/01/2008 7:55:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35741A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

B35766

99

4.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

B36840

99

5.0

D35641

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE

Batch: B33243

99

6.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
GASKET

Batch: 1x=> B37410 1x=> B37813

99

7.0

D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE

B33801

99

8.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE

B37212

99

08-03-17

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35741A

Part Number: D412742043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D35665	GASKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B37411

*GR*

10.0	AN3C4A	BOLT
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: M1107008

*GR*

11.0	AN3C6A	BOLT
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: M1105306

*GR*

12.0	AN3C7A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: M1105906

*GR*

13.0	AN960C10L	washer
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Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: M1107242

*GR*

14.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*S 08/03/18 (41)*

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev: PP 35741

*8/3/20 SQ (A)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: P Date: 28/03/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35741A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



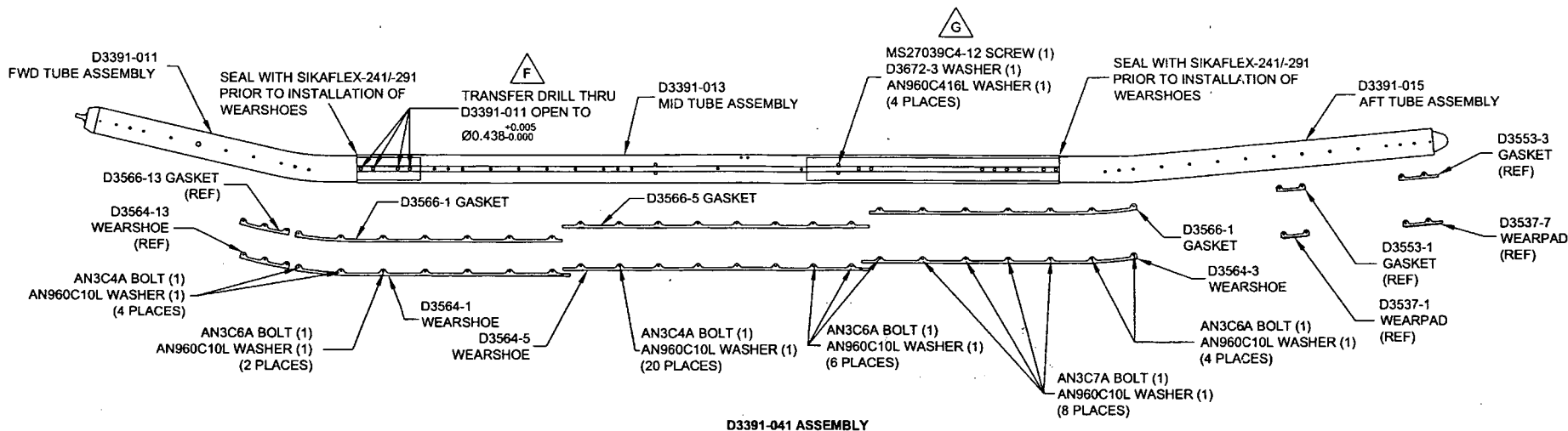
Comment: FINAL INSPECTION/W/O RELEASE

①  
D 08/03/24

Job Completion



U 08-03-24



RELEASED  
07-11-06

#### D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

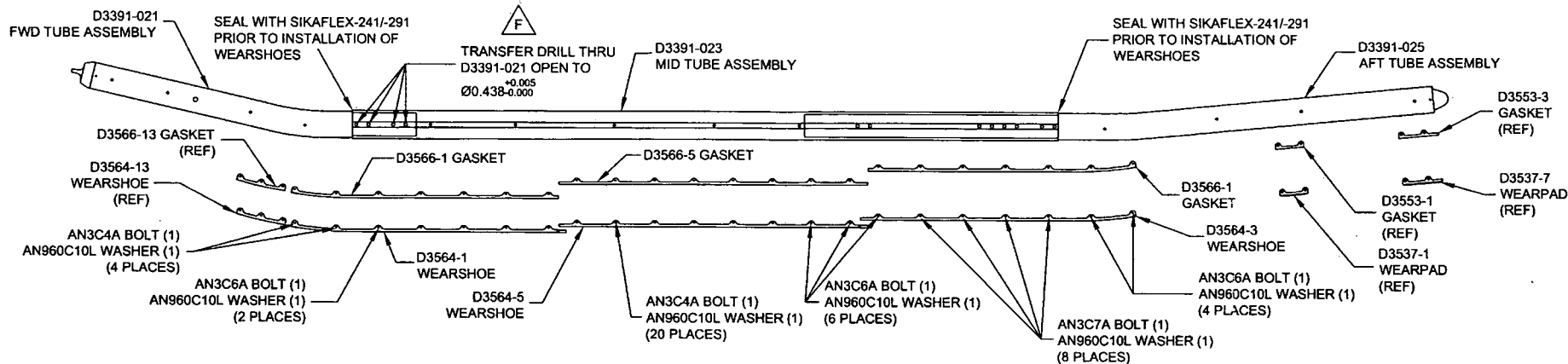
QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS, COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.
- 4)
- 5)

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G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -0111-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		
<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA DRAWING NO. D3391 412 FLOAT SKIDTUBE REV. G SHEET 1 OF 8 SCALE NTS <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



**D3391-043 ASSEMBLY**

**RELEASED**  
07.11.21

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

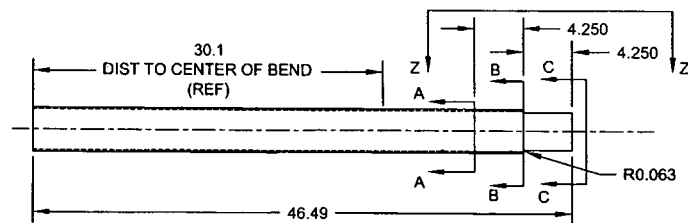
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X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

**GENERAL NOTES**

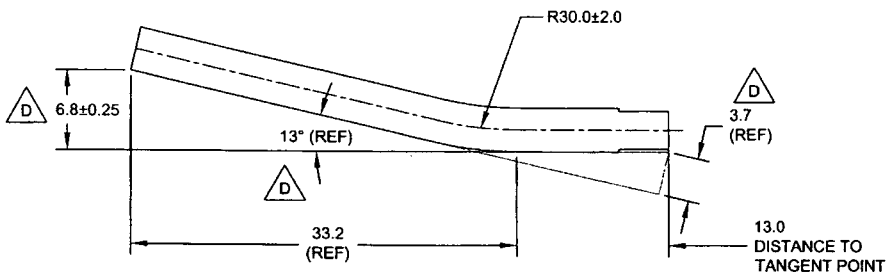
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
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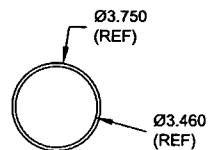
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MFG. APPR.	MD	D3391	SHEET 2 OF 8
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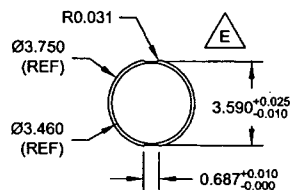
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



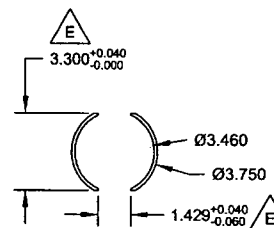
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



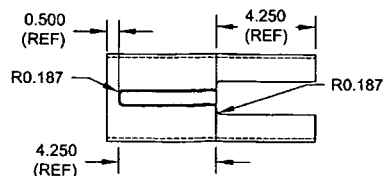
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**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)



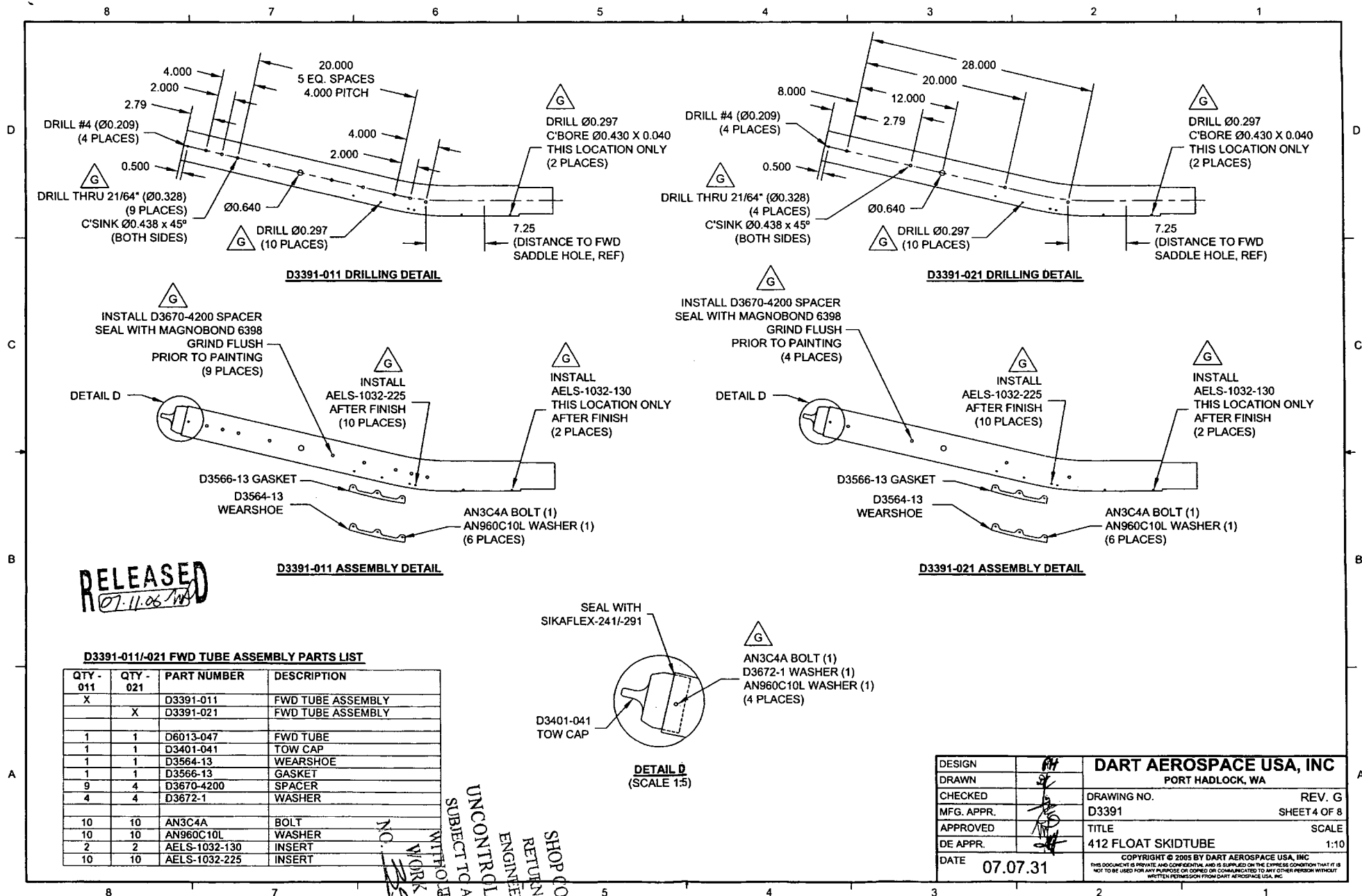
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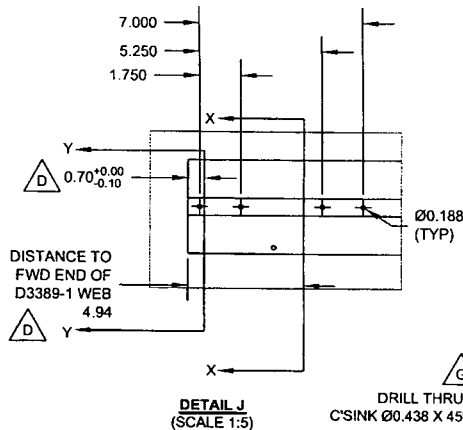
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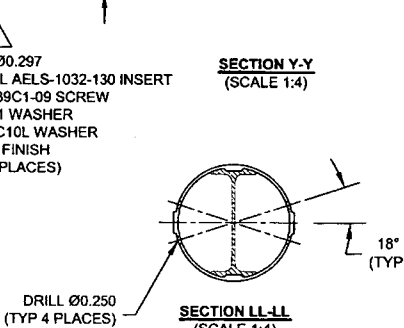
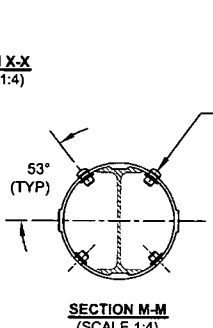
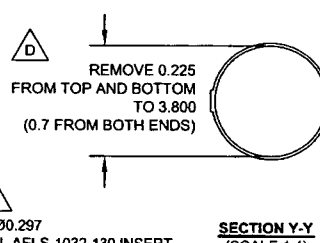
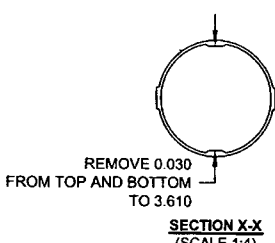
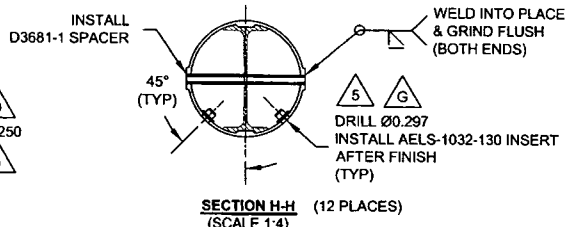
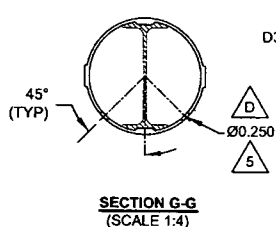
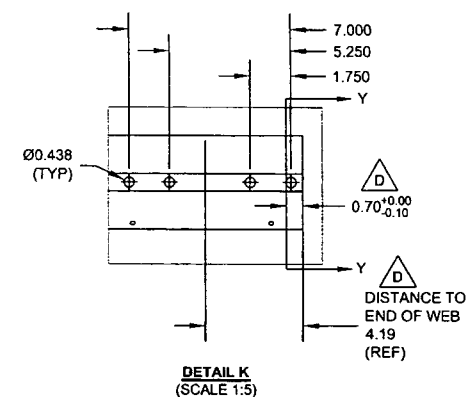
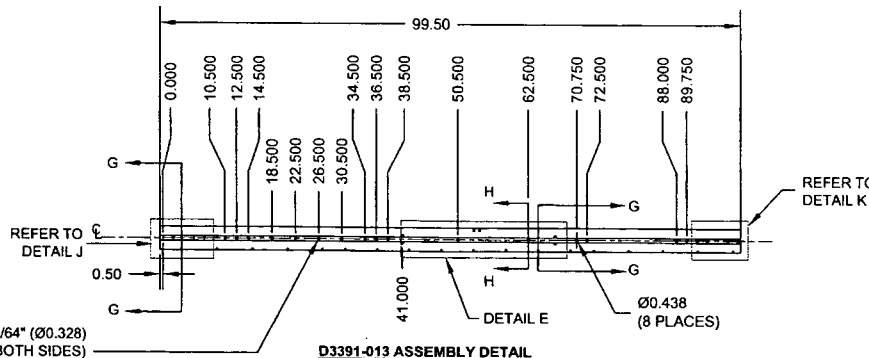
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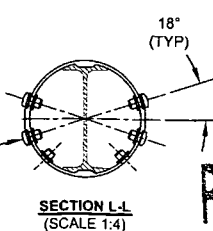
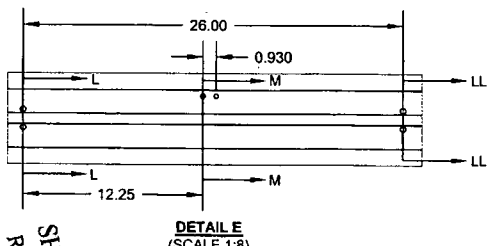


DRILL THRU 21/64" (Ø0.328)  
C'SINK Ø0.438 X 45° (BOTH SIDES)  
(12 PLACES)



**D3391-013 MID TUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



**D3391-013 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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DE APPR.	JP	412 FLOAT SKIDTUBE	1:20
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